

# Work Order ID 67253

Monday, March 14, 2011 10:47:10 AM

*BLUE*



Page 1

Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

*C2*

Date: 11/03/14 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2932	Rev C								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

*ml 11.3.23*

*4*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*ml 11.3.23*

*4*

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

*ml 11.3.23*

*4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 67253

Monday, March 14, 2011 10:47:10 AM



Page 2

Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check	0.00				4			
135  SprayPaint Spray Painting	<i>Hand Sampling</i> <i>chemical conversion</i>	0.00 <i>11/3/28</i>				4			
155  SprayPaint Spray Painting	Spray Painting per QSI005 4.2	0.00							
	<b>Memo</b> Spray Painting: prime grey B: 115967 spray paint defleet blue B: 115985 clear del fleet B: 117113	0.00							
160  QC Quality Control	QC3- Inspect Part Finish <i>QC 14</i>	0.00							
	<b>Memo</b>	0.00							

4 BL 11-3-28.

11 04 07 (4)

ET 11-04-08 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67253**

Monday, March 14, 2011 10:47:10 AM



Page 3

Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: 421

0.00



Packaging

Memo

0.00

Packaging

11/4/11

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12 11.04.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, March 14, 2011 10:47:06 AM

Page 1

Work Order ID: 67253



Parent Item: D2932-2



Parent Item Name: Saddle RH Out, 206


Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC  
IPP Rev:C As per Rev C 07-03-19 JLM □

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	8.0000	1	4		11.3.23	

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT	2	
65151	2	
MAT042	6	
65175	6	

should be 8

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	67253
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2932-2
<b>Inspection Dwg:</b> D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

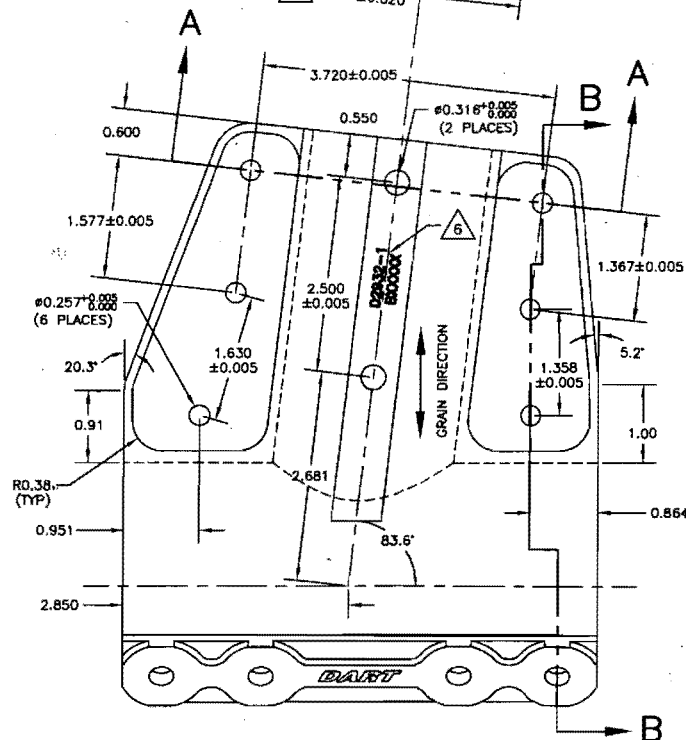
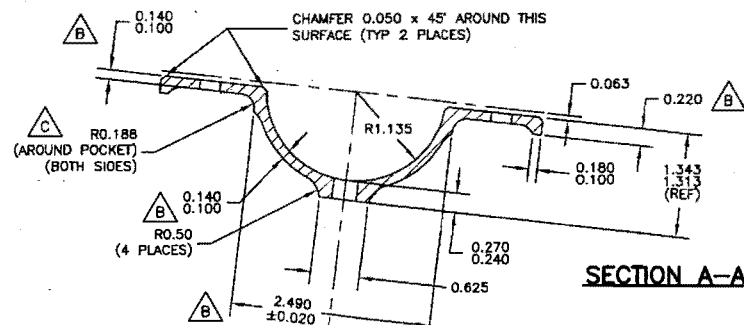
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.139	.133	.135	.134		
B	0.100	0.140		.139	.133	.135	.134		
C	0.100	0.140		.136	.125	.126	.127		
D	0.210	0.230		.222	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.512	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.239	.237	.235	.238		
N	0.100	0.140		.110	.109	.110	.109		
O	0.540	0.560		.547	.547	.547	.547		
P	0.490	0.510		.503	.503	.501	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.491	2.491	2.491		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.128	.128	.128	.128		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.137	1.137	1.138	1.136		
Y	1.565	1.585		1.577	1.577	1.578	1.577		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	11.3.28

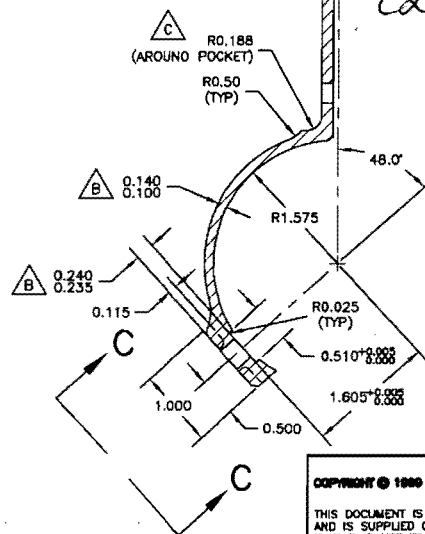
Audited by:	<i>[Signature]</i>
Date:	11.3.28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

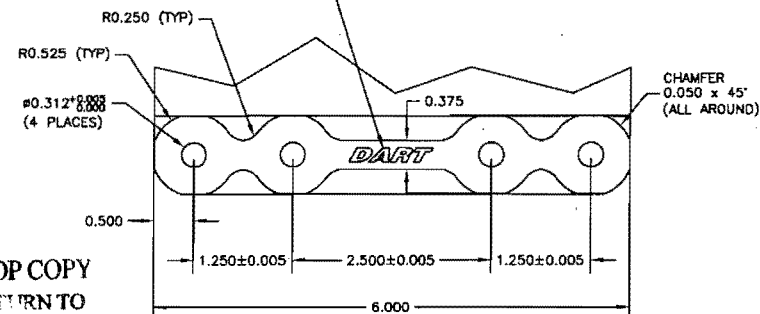




SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH  
OF 0.005 WITH MIN RAD 0.250



VIEW C-C

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 67253  
CZ11/03/14

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
PH	CB	D2932	SHEET 1 OF 1
DATE		TITLE	SCALE
06.11.09		SADDLE OUTSIDE	2:3

RELEASED

07-02-12

